



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2432
Job Sheet 178553



Part No: D2432

Job Qty: 12 ea

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Container		OK R/06/12
120	Waterjet	12 pcs	6/29/18	6/29/18	0.00	3.09	Waterjet 2 OMAX		OK 18/06/13
130	CNC Vertical Machining	12 pcs	6/29/18	6/29/18	0.36	15.40	HAAS 1		OK 18/06/14
140	QC	12 pcs	6/29/18	6/29/18	0.00	0.00	QC2		OK 18/06/14
150	QC	12 pcs	6/29/18	6/29/18	0.00	0.00	QC8		OK 18/06/14
160	Packaging	12 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3	5/4/15	OK 18/06/14
170	QC21-SA	12 Ea	6/29/18	6/29/18	0.00	0.00	QC21		OK 18/06/14

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	44.4000 sf (3.7 ea)	90-Start up Operation	3045595

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	44	1,432	0

Part Specifications

Specifications could not be found.

Plex 6/1/18 1:50 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Date : _____

Description Work O. _____



Date: 08/13/18

UPDATE

Work Order update only ☐



AGAINST DEPARTMENT/PROCESS

Tube	Water Jet	Engineering
	Prod. Eng. Coord.	Quality
	Rec/Store/Packaging	Other
	Supplier	

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

Temp. Cure	☐
Set-up	☐
BOM/Route	☐
Broken/Damage/Defect	☐
Inspection Incomplete/Unqualified	☐
Contamination	☐
Countersink	☐
Cut Too Short	☐
Instructions Incomplete/Unclear	☐
Drill Holes	☐

FAULT CATEGORY

Power Loss/Surge	☐	Positioned Wrong	☐
Folio/Program	☐	Outside Dimensions	☐
Grain	☐	Over/Under tolerance	☐
Weld	☐	Part Incorrect	☐
Wrong Stock Pulled	☐	Part Lost/Missing	☐
Out of Sequence	☐	Part Moved	☐
Off-set	☐	Drawing	☐
Mislabeled	☐	Finish	☐
Fit/Function	☐	Misread	☐
Misaligned/off center	☐	Turning Sequence	☐

OTHER : _____

DART AEROSPACE LTD		Work Order: 178553
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Ver	
B 0.200	+/-0.030	0.200	✓		D.G.	
C 0.25 x 45°	+/-0.030	0.25 x 45°	✓		Ver	
D R0.250	+/-0.030	R0.250	✓		R.G.	
E 0.250	+/-0.010	0.250	✓		Ver	
F 0.625	+/-0.030	0.630	✓		Ver	
G 0.375	+0.030/-0.010	0.385	✓		Ver	
H 0.950	+/-0.030	0.955	✓		Ver	
I 19.000	+/-0.030	19.000	✓		TAPE	
J Ø0.260	+0.005/-0.000	Ø0.260	✓		G.P.	
K Ø0.93	+/-0.030	Ø0.93	✓		Ver	
L 0.30	+0.030/-0.000	0.315	✓		D.G.	
M 23.750	+/-0.030	23.750	✓		TAPE	
N 2.000	+/-0.030	2.000	✓		Ver	
O 0.38	+/-0.030	0.38	✓		Ver	
P						
Q						
R						
S						
T						
U						
V						

Measured by: DAS 52 9-89	Audited by: [Signature]	Preliminary Approval:
Date: 18/06/23	Date: 18/07/23	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	[Signature]